\*11**0**\*

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Quality Control

Memo

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

OAS 13/11/13

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DQA:	<u>Q</u>	lot-	Date:	(4/e	N24	WORK ORDER NON	-CC	ONFOR	RMANCE / UPDATE				DART
QA Closed	: A	01	Date:	14/	118			-		Wc	ork Order up	date only	
Work Or	der:	1091	34			DISPOSITION			AGAINST	DEI	PARTMENT	PROCESS	
Part	No.	D348°	8-04			Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root Cause		Date	Step	Qty	Desci	ription of work order update or non-conformance	1	nitial ief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Toolin Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved	W X	13/11/12	160	١	Re: (	perata NOT used To prevate This Hachive.	PA'C	As 22 34.13	BORE WAS BUFFER. TO BRING THE SURFACE TO A SMOOTH FINISH, ROLD ROLD ROLD WITHIN TOLDRANCE.		0AS 40 2-89 13/11/12	enf 12/11/ab	DAS 16 9-89 13/4/13
Unapproved		L	<u> </u>		1	-A(K)	FA	ULT CA	TEGORY				
Lan	ding (	Gear				General							
		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea	nk/Ripple			Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short		Grain Hardwa Inspect Instruct	tion Incomplete/Unqualified tions Incomplete/Unclear gned/off center		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		Inspection		Tube	-	Drawing		Misrea	· ·			- L	
1		Marks/Ch	-			Drill Holes		Off-set					
1		Turning S				Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	е		Fit/Function		Out of	Sequence				

QC

**Quality Control** 

\*109134\*

Page 2

November-11-13 3:21:13 PM Item ID: D3488-042 Accept \*N900040100\* Setup Start **Revision ID:** Stop Blade Fitting RH Item Name: \*10\* **Start Qty: 10.00 Start Date:** 11/11/13 **Cust Item ID:** Required Date: 11/25/13 Rea'd Otv: 10.00 \*10\* **Customer:** Reference: Run Date: Approvals: Tooling: Date: Stop SPC (Y/N): Date: Date: Sequence ID/ Operation Set\_Up/-Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Code Qty Qty Number Stamp **Run Hours** 120 0.00 HAAS CNC VERTICAL MACHINING #1 \*120\* HAAS I 0.00 Memo HAAS CNC vertical machine #1 1-Machine as per Folio FA627 & Dwg D34882-Deburr-130 QC2- Inspect parts off machine FAI/FAIB 0.00 \*130\* 10 8 13-11-19 QC 0.00 Memo Quality Control ml 1.1/1/20 0.00 OC8- Inspect parts - second check 140 10 0

0.00

Memo

DQA:			Date:						_					TRAC
			<b>D</b>			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		١٨/٥	ork Order up	odata only	AEROSPACE
QA Closed:			Date:								VVO	ik Oldel up	date only	
Work Orde	ır.					DISPOSITION	ļ			AGAINST I	DEF	PARTMENT	/PROCESS	
Work Orac	-				_	Rework			Skid-tube	Crosstube			Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality
						Use-as-is			noforming	Finishing	_	Rec/Sto	e/Packaging	Other
NCR N	10.		<del></del>	····		Suspected Unapproved			Large Fab	Composite			Supplier	
Root					Desc	ription of work order update		nitial	Act	ion	-	Sign &		
Cause	1	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector
Design														,
Doc/Data		į												
Equip/Tooling									1					
Handling/Pre														
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Offset/Setup				•										
Process														
Supplier														
Training					•									
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Unapproved														
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Landi	ng G	Gear				General		_		_		_		_
		Bending				Bend		Folio/F	rogram			Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorre	cí	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified		Part Lost/Mi	issing	Weld
		Cuffs				Contamination		Instruct	tions Incomplete/i	Unclear		Part Moved		Wrong Stock Pulled
		Crushing	•			Countersink		Misalig	ned/off center			Positioned V	Vrong	
		Heat Trea	at			Cut Too Short	Г	Mislabe	eled			Power Loss/	'Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d	•				
		Marks/Ch	natter			Drill Holes	Г	Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	<u>/ist in T</u> ul	oe		Fit/Function		Out of	Sequence					

## \*109134\*

Page 3

November-11-13 3:21:13 PM Item ID: D3488-042 Accept \*N900040100\* Setup Start **Revision ID:** Step Item Name: Blade Fitting RH \*10\* **Start Date:** 11/11/13 **Start Qty: 10.00 Cust Item ID:** Required Date: 11/25/13 Req'd Qty: 10.00 \*10\* **Customer:** Reference: Run Start Process Plan: Date: Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ **Tool ID** Operation Set Up/ Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp Chemical Conversion Coat per QSI005 4.1 150 0.00 10 & CF 13-11-21 \*150\* HandFinish 0.00 Memo Hand Finishing 160 White Gloss(Ref:4.3.5.1), per QSI005 4.3-Alum 0.00 10 \$ 13-11-21. \*160\* Powdercoat 0.00 Memo OVEN TEMPERATURE: Powder Coating 170 QC3- Inspect Part Finish 0.00 IORH of Ill islicity \*170\* QC 0.00 Memo Quality Control

Quanty Conti

WORK ORDER NON-CONFORMANCE / UPDATE  Work Order:  Part No.  Part No.  Disposition  Rework Scrap Use-as-is Suspected Unapproved  Root Cause  Date  Step Qty  Description of work order update or non-conformance  Design Unapproved  Description  Root Cause  Date  Step Qty  Description of work order update or non-conformance  Description  Description  Date  Verification  QC Inspector  Adainst DEPARTMENT/PROCESS  Skid-tube Crosstube Machining Nachining Rec/Store/Packaging Rec/Store/Packaging Other  Chief Eng Description  Date  Verification  QC Inspector  Design Handing/Pre Handing/P	DQA:		Date:										TRACT
Work Order:  Part No.  Part No.  Boot Cause Date Date Step Operator Doc/Data Eauly/Tooling Hadding/Pre						WORK ORDER NON-	-CC	ONFO	RMANCE / UP	DATE			AEROSPACE
Nork Order:   Rework   Scrap   Use-as-is   Suspected Unapproved   Use-as-is   Suspected Unapproved   Skid-tube   Crosstube   Prod. Eng. Coor.   Quality   Prod. Eng. Coor.   Quality   Rec/Store/Packaging   Other   Suspected Unapproved   Suspected Unapproved   Composite   Suspected Unapproved   Composite   Suspected Unapproved   Composite	QA Closed:		Date:							M	ork Order up	odate only	
Rework Scrap   Skid-tube   Crosstube   Machining   Small Fab   Prod. Eng. Coor.   Quality   Prod. Eng. Coor.   Quality   Composite   Suspected Unapproved   Large Fab   Composite   Suspected Unapproved   Large Fab   Composite   Suspected Unapproved   Chief Eng   Composite   Suspected Unapproved   Chief Eng   Composite   Sign & Verification   QC Inspector   Quality   Quality						DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part No.    NCR No.	Work Order:	·		_			,		Claid Author	C		Water let	7
NCR No.    Suspected Unapproved   Suspected Unapproved   Large Fab   Composite   Supplier   Other	D - + N -					—	1			<del> </del>	- Dra	<u> </u>	<b>-</b>
Root Cause Date Step Qty Description of work order update or non-conformance Chief Eng Description Date Verification QC Inspector  Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offiset/Setup Troining Transport Unapproved Unapproved Date Were General  Equip/Tooling Handling/Pre Material Operator Offiset/Setup Handling Material Description Date Were General Bending Gear General  FAULT CATEGORY  FAULT CATEGORY  Landing Gear General  Bending Centre Not Concentric BOM/Route Folio/Program Outside Dimensions Over/Under tolerance Set-up	Part No	•	· · · · · · · · · · · · · · · · · · ·			· · · · · · · · · · · · · · · · · · ·			~ <del>  </del>	<u> </u>	<b>⊣</b>		
Root Cause Date Step Qty Description of work order update or non-conformance Chief Eng Description Date Verification QC Inspector Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved Unapproved Bending Gear General Bending Centre Not Concentric BoM/Route Folio/Program Outside Dimensions Over/Under tolerance Set-up	NCP No						┨┨	mem	~ <del></del>	_ <b> </b>	Rec/310		
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector  Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved Handling Gear General  Bending Gear General  Bending Centre Not Concentric BoM/Route Folio/Program Over/Under tolerance Set-up	NCK NO	'·		-		Juspected Onapproved	J		raige rab	composite		20ppiici _	
Cause   Date   Step   Qty   or non-conformance   Chief Eng   Description   Date   Verification   QC Inspector	Root		<b>4</b> ~	İ	Desc	ription of work order update	П	nitial	Acti	on	Sign &		
Design		Da	e Step	Qty		· ·	Ch	ief Eng	Descri	ption	_	Verification	QC Inspector
Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved Handling Gear General Bending Centre Not Concentric BOM/Route Folio/Program Over/Under tolerance Set-up	Design												
Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved FAULT CATEGORY  Landing Gear General Bending Bend Folio/Program Outside Dimensions Pressure/Forced Set-up	Doc/Data	1		1									
Material Operator Offset/Setup Process Supplier Training Transport Unapproved Sending Gear General Bending Bend Folio/Program Outside Dimensions Pressure/Forced Set-up	Equip/Tooling	]							•		ŀ		1
Operator Offset/Setup Process Supplier Training Transport Unapproved  Landing Gear Bending General Bending Centre Not Concentric BOM/Route  FAULT CATEGORY  Folio/Program Outside Dimensions Over/Under tolerance Set-up	Handling/Pre												
Offset/Setup Process Supplier Training Transport Unapproved  Handing Gear Bending Bend Centre Not Concentric BOM/Route  FAULT CATEGORY  Folio/Program Outside Dimensions Pressure/Forced Set-up  Process  FAULT CATEGORY  Folio/Program Outside Dimensions Over/Under tolerance Set-up	Material					·							
Process Supplier Training Transport Unapproved Unapproved  Landing Gear Bending Centre Not Concentric BOM/Route  FAULT CATEGORY  FOlio/Program Outside Dimensions Pressure/Forced Grain Over/Under tolerance Set-up	Operator						Ì						
Supplier Training Transport Unapproved  Landing Gear  General  Bending Centre Not Concentric  BOM/Route  FAULT CATEGORY  FOlio/Program Outside Dimensions Over/Under tolerance Set-up	Offset/Setup	_	Ì	Ì			ł						
Training Transport Unapproved FAULT CATEGORY  Landing Gear General Bending Bend Folio/Program Outside Dimensions Pressure/Forced Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up	Process	_											
Transport Unapproved FAULT CATEGORY  Landing Gear General  Bending Bend Folio/Program Outside Dimensions Pressure/Forced Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up	Supplier	4											
Centre Not Concentric   BOM/Route   FAULT CATEGORY   FAULT CATEGORY   FOlio/Program   Outside Dimensions   Pressure/Forced   Grain   Over/Under tolerance   Set-up   Set-up   Set-up   Centre Not Concentric   Centre Not Co	Training	4											
FAULT CATEGORY  Landing Gear General  Bending Bend Folio/Program Outside Dimensions Pressure/Forced Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up	Transport	4	1	ł									
Landing Gear  Bending  Centre Not Concentric  General  Folio/Program  Folio/Program  Grain  Outside Dimensions  Pressure/Forced  Grain  Over/Under tolerance  Set-up	Unapproved	<u> </u>			<u> </u>				]	·			
Bending Bend Folio/Program Outside Dimensions Pressure/Forced Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up							FA	ULT CA	TEGORY		<u> </u>		······································
Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up	Landing	_				<b>1</b>	_	1 ,-	_	_	<b>7</b>	. –	<b>-</b>
		-1	_		_		-	1	Program	<u> </u>	⊣		····
I I I I I I I I I I I I I I I I I I I	!			ntric	-		-	1		<u> </u>	⊣ `	<del> </del>	<b></b> i '
	l	-				<b>T</b>	$\vdash$	4		<u> </u>	<b>-</b>	<del> </del>	
Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Weld	<u> </u>	┥ '	/Kink/Ripple	e/Wave	$\vdash$		$\vdash$	1		_	<del>-</del>	issing	<b></b> ∤
Cuffs Countersial	<u> </u>	-1	:		 	4	$\vdash$	-1	=	nciear		<u> </u>	
Crushing Countersink Misaligned/off center Positioned Wrong Heat Treat Cut Too Short Mislabeled Power Loss/Surge Other	<u> </u>		_		-	-	$\vdash$	-	•	-		_	Joshan
				Tuba	-	4	-	4		L	rower Loss/	onike [	Totner
Inspection Strip in Tube Drawing Misread  Marks/Chatter Drill Holes Off-set	<del> </del>	<b>⊣</b> `	-	i iube	-	┥ ~	$\vdash$	4					
Turning Sequence Finish Out of Calibration	-	-			$\vdash$	4	$\vdash$	4					
Wave/Twist in Tube Fit/Function Out of Sequence	<del> </del>	_			-			-			-		

<b>Work Ord</b> November-11-1.				*109	134*							Pag	e 4
Item ID: Revision ID: Item Name: Start Date: Required Date:	D3488-042  Blade Fitting 11/11/13 : 11/25/13	RH Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*	Accept	*N9000 Cust Item ID: Customer:		100	<b>)</b> *	Setup	Start Stop	*N:		
Reference: Approvals:		an:	Date:	Tooling: SPC (Y/N):	Date Date	e:			Run	Start Stop	*NI *NI	₹1* ₹2*	
Sequence ID/ Work Center I  180  *180* HandFinish Hand Finishing	D	Operation Description  HandFinishing  Memo Install Inserts	as per Dwg D3488	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Qty	, I	Reject Number	Insp. Stamp	lizli
190 <b>*190 QC</b> Ouality Control		QC5- Inspect part comple	teness to step on W/O	0.00				10	Ø	, /E	31219	,	DAS 34 9-89

200

Identify as per dwg & Stock Location: F7 -06 0.00

\*200\* Packaging

Packaging

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Memo

0.00

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DQA:			Date:			WORK ORDER NON	~	NEO	DAAANGE / LIDE	DATE			DART
QA Closed:			Date:			WORK ORDER NON-	-CC	NFOI	RIVIANCE / UPL		ork Order up	date only	AEROSPACE
Work Orde				-		DISPOSITION		•		AGAINST D	EPARTMENT,	/PROCESS	
Work Orde	er.					Rework	ı		Skid-tube	Crosstube	7	Water Jet	Engineering
Part i	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite	]	Supplier	
Root					Desci	ription of work order update	ı	nitial	Actio	n	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector
Design													
Doc/Data							İ						
Equip/Tooling													
Handling/Pre			1				İ						
Material		!											
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Offset/Setup													
Process					Ì								
Supplier		•											
Training													
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							FA	ULT CA	TEGORY				
Landi	ng (	Gear				General		_		_	_	_	_
		Bending			L	Bend		Folio/f	Program	L	Outside Dim	ensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		<u>L</u>	Over/Under	tolerance	Set-up
		Cracks			L	Broken/Damage/Defect		Hardwa	are		Part Incorre	ci _	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	tion Incomplete/Unq	ualified	Part Lost/Mi	ssing	Weld
		Cuffs			L	Contamination		Instruc	tions Incomplete/Un	clear	Part Moved	L	Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong _	_
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Ch	natter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	oe .		Fit/Function		Out of	Sequence				

\*109134\*

Page 5

November-11-13 3:21:13 PM Item ID: D3488-042 Accept \*N900040100\* Setup Start **Revision ID:** Stop Blade Fitting RH Item Name: \*10\* **Start Date:** 11/11/13 **Start Oty: 10.00 Cust Item ID:** Required Date: 11/25/13 Req'd Qty: 10.00 **Customer:** Reference: Run Start Process Plan: Date: **Tooling:** Approvals: Date: Stop QC:\_ Date: **SPC (Y/N):** Date: Sequence ID/ Operation Tool ID Tool # Plan Reject Set Up/ Accept Reject Insp. Number Stamp Work Center ID Description **Run Hours** Code Qty 210 QC21- Final Inspection - Work Order Release 0.00 1/30 MF (3-12-20) 0.00 Memo Quality Control

DQA:			Date:											
						WORK ORDER NON-	-CC	NFO	RMANCE / UPDATE				_	AEROSPACE
QA Closed:			Date:							Wo	ork Order up	date only		
Work Orde	. r.					DISPOSITION			AGAINST	DEI	PARTMENT	PROCESS		-
Work Orde	٠.					Rework	\		Skid-tube Crosstube	П		Water Jet		Engineering
Part N	No.					Scrap			Machining Small Fab	-	Pro	d. Eng. Coor.	┨	Quality
	•					Use-as-is		Thern	noforming Finishing		Rec/Stor	e/Packaging		Other
NCR I	۷o.			_		Suspected Unapproved			Large Fab Composite			Supplier		
84			1		Doss	vintion of work order undate		nitial	Action	-	Sign &	<del></del>	$\neg$	
Root	I	Data	Ston	Otv	Desci	ription of work order update or non-conformance	l	initial	Description		Date	Verification	-	QC Inspector
Cause Design	$\dashv$	Date	Step	Qty		or non-comormance	CII	iei ciig	Description		Date	Verification	$\dashv$	Qe mspector
Doc/Data	$\dashv$												Ì	
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Landi	ng (	ı				General		]	<b>.</b>		Outside Dim	:_ Г	_	Pressure/Forced
	_	Bending Centre No	-+ Camaan			Bend BOM/Route	$\vdash$	Grain	Program	$\vdash$	Over/Under	- <del>-</del>	_	Set-up
		Cracks	or concer	ILIIC	<del> </del>	Broken/Damage/Defect	$\vdash$	Hardwa	aro	$\vdash$	Part Incorre		_	Temperature/Cure
5	-	Crimp/Kir	nk/Rinnle	/Wave	-	Burrs	$\vdash$	4	ion Incomplete/Unqualified	$\vdash$	Part Lost/Mi	<del>-</del>	_	Weld
	一	Cuffs		, TTGVC		Contamination	$\vdash$	• '	tions Incomplete/Unclear		Part Moved		_	Wrong Stock Pulled
	-	Crushing				Countersink	$\vdash$	4	gned/off center	_	Positioned V	L Vrong		
	$\vdash$	Heat Trea	at			Cut Too Short	$\vdash$	Mislab	=	_	Power Loss/			Other
		Inspectio		Tube		Drawing		Misrea		_	•	- [		
		Marks/Ch	•			Drill Holes		Off-set						
	$\Box$	Turning S				Finish		Out of	Calibration					
	Г	Wave/Tw	ist in Tub	oe .		Fit/Function		Out of	Sequence					

Page 1

Work Order ID: 109134

\*109134\*

Parent Item:

D3488-042

\*D3488-042\*

Parent Item Name: Blade Fitting RH

**Start Date:** 11/11/13

Required Date: 11/25/13

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 06-02-28 JLM

IPP Rev:B As per Rev B 06-03-30 JLM

IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No				Each	92.0000		40		· · · · · · · · · · · · · · · · · · ·	
*AI \$7-10	32-225*	* ALS	4 -	1032- 2	225				** (	4(270	97 (x	40)	el osni
				Location	<u>l</u>	Loc Q	<u>oty</u>	Loc Code					
				FG			80		_		_		
					118520		80				_		
				ST280			12		_		_		
					122333		12						
D6103-003		Manufactured	No				Each	38.0000		10			
*D6103-0	ივ*								**	<del></del>			
Round Billet, Aluminum				<u>Location</u>	<u>1</u>	Loc Q	<u>oty</u>	Loc Code			OA	S	1.1.
				MAT			12				<b>4(</b> 	13/	11/12
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					95020		4						
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DQA:			Date:			WORK ORDER NON-	·cc	NEOI	DMANCE / HD	DATE				•	DART
QA Closed:			Date:			WORK ORDER NON-		JINFOI	NIVIAINCE / OF		Wo	ork Order up	date only	П	AEROSPACE
Work Orde	or.	-	-			DISPOSITION			-	AGAINST	DE	PARTMENT	PROCESS		
Part N	lo				_	Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Desci	iption of work order update	I	nitial	Actio	on		Sign &			•
Cause	1 [	ate	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verificatio	n	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Dperator Dffset/Setup Process															·
Training Transport	_						•								
Unapproved									ļ						
1			, -	<u>.</u>			FA	ULT CA	regory						
Landir	ng Gea	•		,		General									
	Cei Cra Cri Cu Cru He Ins	ncks mp/Kin ifs ishing at Trea pection	Strip in	/Wave Tube		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misread Off-set	ion Incomplete/Und tions Incomplete/Un gned/off center eled d	-		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ci ssing Vrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
	W	ve/Twi	ist in Tuk	oe		Fit/Function		Out of	Sequence						

DART AEROSPACE LTD	Work Order:	109134
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2	Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
	<u> </u>		l Section		<u> </u>	
Ø2.150	+/-0.005	2.155			VERN	P40-12
Ø2.780	+/-0.005	2.779	/		h	1,
Ø3.125	+/-0.010	3, 124			١.	CNC-OZ
Ø3.346	+/-0.010	3,346	/		,,	. •
0.125 x 45°	+/-0.010 x +/-0.1°	- 125	/		٠,	. 11
8.000	+0.030/-0.000	8,012			۶,	1.
9.250	+/-0.010	9, 251	/		15	••
0.188	+/-0.010	.186	<b>/</b>		,1	PHO-12
R0.032	+/-0.010	.032	/		Rad G	
R0.062	+/-0.010	.063	/		Rad 6	
Ø0.297	+0.005/-0.001	.300			PiN G	
Ø0.430	+/-0.010	. 433	V		1 \$	
0.100	+/-0.010	, 102	/		Mic	PHO-09
0.125	+/-0.010	. 130			VERN	PUD-12
2.620	+/-0.010	2.619			<i>t</i> (	CNC-OZ
3.500	+/-0.010	3,500			13	PUO-12
1.005	+/-0.010	1.005			H. G.	
Ø0.484	+0.005/-0.001	.486	V		11N 6	
1.180	+/-0.010	1,180	/		VERU	P40-12
3.150	+/-0.010	3,148			15	2)
3.070	+/-0.010	3,070			H. G.	
R0.063	+/-0.010	. 063			Rud G	

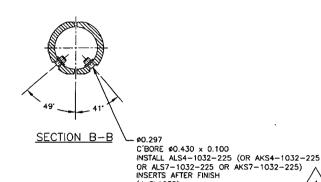
DART AEROSPACE LTD	Work Order:	109134
Description: Blade Fitting, RH / Turning Detail for D3488-1/-2	Part Number:	D3488-2
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
		Milli	ng Section	1		
Ø0.508	+0.006/-0.001	508			Vein	JL-10
0.750	+/-0.010	75			N-G	
1.500	+/-0.010	1,500			New	
11.18	+/-0.030	11,178			U-G	
R0.062	+/-0.010	-062	//			
0.125	+/-0.010	-125			Noin	
0.590	+/-0.010·	-589			HG	
0.793	+/-0.010	791			<u>``</u>	
1.351	+/-0.010	1,354			_	
1.317	+/-0.010	134			NOLH	
1.802	+/-0.010	1-80Q			Jr G	
			,			
	100					

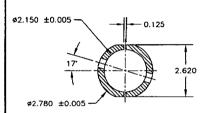
Measured by: 3-83 SL Audited by: Prototype Approval: N/A

Date: 3/11/3 13-11-19 Date: 13/11/2 Date: N/A

Rev	Date	Change	Revised by	Approved
Α	06.03.31	New Issue	KJ/JLM	
В	08.09.19	Reformat P/O D3488-042	KJ/JLM 1,A	21
С	08.12.02	Dimension 8.000 removed	KJ/JLM 🛠	



(4 PLACES)



SECTION A-A

## 03488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3488-041	BLADE FITTING ASSEMBLY (LH)
	X	D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

## D3488-041/-042 BLADE FITTING

1) MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR

PER QQ-A-225/9

(REF. DART MATERIAL SPEC M7075T73R)
FINISH ACID FTCH ALODINE PER DART OSL 005

ACID ETCH, ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

BREAK UNMARKED SHARP EDGES 0.010 TO 0.020

4) INSTALL INSERTS AFTER POWDER COAT

5) ALL DIMENSIONS ARE IN INCHES

6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

